

Work Order ID 60982

August 3, 2010 2:47:20 PM



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Item ID:	D2873-045	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Nut Plate Assembly					
Start Date:	8/03/10	Start Qty:	20.00		Cust Item ID:	
Required Date:	8/13/10	Req'd Qty:	20.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	10-8-03	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2873	Rev A								
100		0.00							
	BAND SAW								
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blanks: 1.000" x 0.375" x 2.700" long								
110		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Machine as per Folio FA and Dwg D2873 Identify as D2873-5 Dwg Rev <u>A</u> F1819Folio Rev <u>LA</u>								
120		0:00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

SP 10/08/09

OK 10/08/11

OK 10/08/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID:	D2873-045	Accept		Setup	Start	
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Required Date:	8/13/10	Req'd Qty:	20.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		B.A		20	0		
140 Small Fab Small Fab	Small Fab Memo 1-Deburr □2- C'sink as per Dwg D2873	0.00 0.00							
150 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		S					

Handwritten signature and date: 8/5/08/16 (20)

Handwritten signature and date: (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID:	D2873-045	Accept		Setup	Start	
Revision ID:					Stop	
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Start Date:	8/03/10	Start Qty:	20.00		Cust Item ID:	
Required Date:	8/13/10	Req'd Qty:	20.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				ml	10	08	16 (20)
170 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		10/08/16		10	0		
180 Small Fab Small Fab Small Fab	Small Fab Memo 1-Assemble as per Dwg D2873 <input type="checkbox"/> 2-Identify as D2873-045	0.00 0.00							SPC/08/17 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			






NOTE: Date & initial all entries

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Item ID: D2873-045 Accept  Setup Start 
Revision ID: Stop 
Item Name: Nut Plate Assembly
Start Date: 8/03/10 Start Qty: 20.00  Cust Item ID:
Required Date: 8/13/10 Req'd Qty: 20.00  Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				20			100818
200  Packaging Packaging	Identify as per dwg & Stock Location: <i>K tube Finishes</i> Memo	0.00 0.00				RT	10.08-19	(20)	
210  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							10/08/19 <i>MF</i> 10-8-19

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 60982

Parent Item: D2873-045

Parent Item Name: Nut Plate Assembly




Start Date: 8/03/10

Required Date: 8/13/10

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A 05.09.13 New issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21075L5  Nut Plate		Purchased	No			100	Each	33.0000	2	40			
<div> <div>Location</div> <div>ST303</div> <div>112243</div> </div> <div> <div>Loc Qty</div> <div>33</div> <div>33</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
M6061T6B0.375X01.00 0  6061T6 BAR .375 x 1.00		Purchased	No			180	f	50.1500	0.225	4.736842			
<div> <div>Location</div> <div>MAT01</div> <div>113325</div> <div>MAT04</div> <div>114352</div> </div> <div> <div>Loc Qty</div> <div>0.45</div> <div>0.45</div> <div>49.7</div> <div>49.7</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> <div></div> </div>													
MS20426AD4-6  Rivet		Purchased	No			180	Each	3,133.000	4	80			
<div> <div>Location</div> <div>ST317</div> <div>110139</div> </div> <div> <div>Loc Qty</div> <div>3133</div> <div>3133</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													

EP 10/08/17
M115438 (400)

4.7368 88 10/08/09

EP 10/08/17
(80)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	40982
Description: Radius Block		Part Number:	D2873-5
Inspection Dwg: D2873 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.50	+/-0.030	2.502	—		Vern	ML-7
1.000	+/-0.010	1.000	—		"	"
0.750	+/-0.010	.750	—		"	"
0.250	+/-0.010	.251	—		"	"
1.000	+/-0.010	1.000	—		"	"
2.000	+/-0.010	2.000	—		"	"
Ø0.128	+0.005/-0.001	Ø.128	—		"	"
0.359	+/-0.010	.358	—		"	"
Ø0.316	+0.006/-0.001	Ø.317	—		"	"
1.000	+/-0.010	1.003	—		"	"
0.250	+/-0.010	.247	—		"	"
0.061	+/-0.010	.059	—		"	"
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	Ø.230 x .128	—		"	"

Measured by:	<i>[Signature]</i>	Audited by:	<i>[Signature]</i>	Prototype Approval:	N/A
Date:	10/08/11	Date:	10/08/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D2873-045	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

WFO 60982
BP10-8-07

